



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

Sol 1432

MT Gloss Black

D4776-3
Job Sheet 168113



Part No: D4776-3

Job Qty: 6 ea

Part Name: Skidtube Clevis



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 11/9/17

Job Tracking No:

Due Date: 11/27/17

Created By: Mario Poulin

Type: SOLD

Description:

Note: GLOSS BLACK

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	6 Ea		11/25/17	0.00	0.00	Start Up Machining		Kt 17-11-20
100	Bandsaw	6 pcs		11/25/17	0.00	0.11	Bandsaw1		Kt 17-11-20
110	CNC Vertical Machining	6 pcs		11/25/17	0.26	5.22	HAAS 1		Kt 17-11-20
120	QC	6 pcs		11/25/17	0.00	0.00	QC2		Kt 17-11-20
130	QC	6 pcs		11/25/17	0.00	0.00	QC8		Kt 17-11-20
140	HandFinish	6 pcs		11/25/17	0.00	0.16	HandFinish1		2017-11-21 JSC
150	QC	6 pcs		11/25/17	0.00	0.00	QC7		BR 17-11-27
160	Powdercoat	6 pcs		11/27/17	0.00	0.07	Powdercoat1	Gloss B.	BR 17-11-27
170	QC	6 pcs		11/27/17	0.00	0.00	QC3		38 9-89
180	Packaging	6 pcs		11/27/17	0.00	0.00	Packaging3	5715	57
190	QC21-SA	6 Ea		11/27/17	0.00	0.00	QC21		

Part Op 100 - Cut Blank at 4.400"

Descriptions: 110 - 1-Machine per folio FB168

160 - START TIME: 10:45 OV: T: 300 FINISH: 11:15

1122878

DAS
21
9-89

NOV 29 2017

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6B1.500X02.500	2	13	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Skidtube Clevis	4.250Inches ± 0.030	4.280 4.220		
2	Skidtube Clevis	2.250Inches ± 0.030	2.280 2.220		
3	Skidtube Clevis	1.688Inches ± 0.010	1.698 1.678		
4	Skidtube Clevis	0.880Inches ± 0.030	0.910 0.850		
5	Skidtube Clevis	0.510Inches + 0.010 - 0.000	0.520 0.510		
6	Skidtube Clevis	1.063Inches ± 0.010	1.073 1.053		
7	Skidtube Clevis	1.380Inches ± 0.030	1.410		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

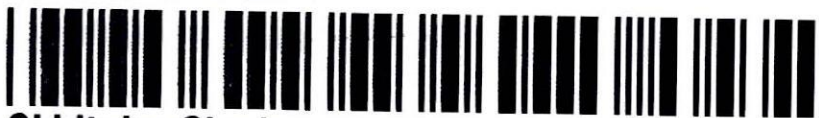
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

	Skidtube Clevis	0.190Inches $\pm$ 0.030	1.350 0.220 0.160	
9	Skidtube Clevis	1.000Inches $\pm$ 0.030	1.030 0.970	
10	Skidtube Clevis	0.484Inches $\pm$ 0.006 - 0.001	0.490 0.483	Diameter
11	Skidtube Clevis	0.500Inches $\pm$ 0.030	0.530 0.470	
12	Skidtube Clevis	0.550Inches $\pm$ 0.030	0.580 0.520	
13	Skidtube Clevis	3.150Inches $\pm$ 0.010	3.160 3.140	
14	Skidtube Clevis	1.130Inches $\pm$ 0.030	1.160 1.100	
15	Skidtube Clevis	0.688Inches $\pm$ 0.010	0.698 0.678	
16	Skidtube Clevis	0.397Inches $\pm$ 0.006 - 0.001	0.403 0.396	Diameter
17	Skidtube Clevis	1.813Inches $\pm$ 0.010	1.823 1.803	
18	Skidtube Clevis	0.190Inches $\pm$ 0.030	0.220 0.160	Radius
19	Skidtube Clevis	0.130Inches $\pm$ 0.030	0.160 0.100	Radius
20	Skidtube Clevis	0.440Inches $\pm$ 0.030	0.470 0.410	Radius
21	Skidtube Clevis	0.125Inches $\pm$ 0.010	0.135 0.115	
22	Skidtube Clevis	0.380Inches $\pm$ 0.030	0.410 0.350	
23	Skidtube Clevis	0.750Inches $\pm$ 0.030	0.780 0.720	
24	Skidtube Clevis	0.250Inches $\pm$ 0.030	0.280 0.220	Radius

Plex 11/9/17 3:11 PM dart.poulin.mario

Fm138109-90
S011328

DART
AEROSPACE
S011432



Skidtube Clevis

PART NO: D4776-3
Revision:
Operation: Packaging
Change No:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Mfg Date: 11/20/17
Job No: 168113

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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